

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016578**Date Inspected:** 30-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Le Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 215960 perform Submerged Arc Welding (SAW) Process on weld joint CB3002C-018-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3169-004-013. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 053742 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3169-003-019. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

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OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 205386 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3181-2-001-009,010. ZPMC Quality Control Personnel (QC) identified as Mr. Guo Pan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 217185 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3181-2-001-003,004. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG # BAY 8

This QA inspector observed that ZPMC Magnetic particle Testing (MT) personnel perform MT of Bike path various weld joints. See attached pictures.

OBG # CROSS BEAM CB11 (BLAST SHOP)

This Quality Assurance (QA) Inspector performed random visual inspection of OBG Cross beam CB11 outside surfaces after grit blasting. Areas that marked for repair were recorded for future repair. And some areas requiring additional grinding were marked by QA Inspector and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for

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your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer